

a developing device for developing the latent image with a developer to thereby form a corresponding toner image; and

an intermediate image transfer body to which the toner image is transferred from said image carrier, said intermediate image transfer body constituting an intermediate image transfer belt for executing primary image transfer from said image carrier to said intermediate image transfer belt and then executing secondary image transfer from said intermediate image transfer belt to a recording medium;

wherein a first raw liquid material is fed into a hollow, cylindrical mold, which is included in a centrifugal molding machine, with said mold being rotated to thereby form an endless first film on an inside of said mold;

a second raw liquid material is fed into the mold with said mold being rotated to thereby for a second film on said first film;

the raw liquid materials respectively forming said first film and said second film are then cured; and said first film forms, when cured, an elastic, first belt layer while said second forms, when cured, a second belt layer having greater hardness than said first belt layer.

Claim 99 (New): An intermediate image transfer belt for an image forming apparatus that comprises an image carrier [for forming a latent image] a developing device [for developing said latent image] with a developer to thereby form a corresponding toner image and said intermediate image transfer belt to which said toner image is transferred from said image carrier, and executes primary image transfer from said image carrier to said intermediate image transfer belt and then executes secondary image transfer from said intermediate image transfer belt to a recording medium, [the method by which the transfer belt is prepared comprising:

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feeding a first raw liquid material into a hollow, cylindrical mold, which is included in a centrifugal molding machine, with said mold being rotated;

curing the first raw material to thereby form a first endless belt layer on an inside of the mold;

feeding a second raw liquid material into the mold with said mold being rotated, and then curing the liquid material to thereby form a second belt layer, with the result that said first belt layer has elasticity while said second belt layer has greater hardness than said first belt layer, and

wherein said first belt layer has a surface gloss of at least 50, a hardness ranging from 30° to 70°, as measured by JIS A scale, and a thickness of 200 to 2000  $\mu\text{m}$  and said second belt layer has a thickness ranging from 30 to 1,000  $\mu\text{m}$  and has a hardness greater than that of said first belt layer.

Claim 100 (New): The belt as claimed in claim 99, wherein a third belt layer different in material from said first layer and said second layer is formed on said second layer.

Claim 101 (New): The belt as claimed in claim 100, wherein the first raw liquid material provides said first belt layer with elasticity after curing while the second raw liquid material provides said second belt layer with hardness greater than hardness of said first belt layer after curing.

Claim 102 (New): The belt as claimed in claim 101, wherein said first belt layer and said second belt layer have a same major composition except for hardness.

Claim 103 (New): The belt as claimed in claim 101, wherein the first raw liquid material comprises thermosetting polyurethane rubber.

Claim 104 (New): The belt as claimed in claim 103, wherein said second belt layer has hardness of 75° or above, as measured by JIS A scale.

Claim 105 (New): The belt as claimed in claim 104, wherein said second belt layer has a Young's module ranging from 200 MPa to 3,000 MPa.

Claim 106 (New): The belt as claimed in claim 99, wherein the second raw liquid material comprises thermosetting polyurethane resin.

Claim 107 (New): The belt as claimed in claim 106, wherein the inside of the mold has smoothness of 1 micrometer or less in terms of a ten-point mean roughness (JIS).

Claim 108 (New): The belt as claimed in claim 107, wherein the inside of the mold has a gloss value of 80 or above.

Claim 109 (New): The belt as claimed in claim 99, wherein the first raw liquid material provides said first belt layer with elasticity after curing while the second raw liquid material provides said second belt layer with hardness greater than hardness of said first belt layer after curing.

Claim 110. The belt as claimed in claim 99, wherein said first belt layer and said second belt layer have a same major composition except for hardness.

Claim 111 (New): The belt as claimed in claim 99, wherein said first belt layer has thickness ranging from 50 micrometers to 2,000 micrometers.

Claim 112 (New): The belt as claimed in claim 99, wherein the first raw liquid material comprises thermosetting polyurethane rubber.

Claim 113 (New): The belt as claimed in claim 99, wherein said second belt layer has hardness of 75° or above, as measured by JIS A scale.

Claim 114 (New): The belt as claimed in claim 99, wherein said second belt layer has a Young's module ranging from 200 MPa to 3,000 MPa.

Claim 115 (New): The belt as claimed in claim 99, wherein the second raw liquid material comprises thermosetting polyurethane resin.

Claim 116 (New): The belt as claimed in claim 99, wherein the inside of the mold has smoothness of 1 micrometer or less in terms of a ten-point mean roughness (JIS).

Claim 117 (New): The belt as claimed in claim 99, wherein the inside of the mold has a gloss value of 80 or above.

Claim 118 (New): An intermediate image transfer belt for an image forming apparatus that comprises an image carrier for forming a latent image, a developing device for developing said latent image with a developer to thereby form a corresponding toner image and said intermediate image transfer belt to which said toner image is transferred from said image carrier, and executes primary image transfer from said image carrier to said intermediate image transfer belt and then executes secondary image transfer from said intermediate image transfer belt to a recording medium, the method by which the transfer belt is prepared comprising:

feeding a first raw liquid material into a hollow, cylindrical mold, which is within in a centrifugal molding machine, with said mold being rotated to thereby form an endless first film on an inner surface of said mold;

feeding a second raw liquid material into the mold with said mold being rotated to thereby form a second belt layer on said first film;

curing the raw liquid materials respectively forming said first film and said second film; and

said first film forms, when cured, an elastic, first belt layer while said second forms, when cured, a second belt layer having greater hardness than said first belt layer; wherein said first belt layer has a surface gloss of at least 50, a hardness ranging from 30° to 70°, as measured by JIS A scale, and a thickness of 200 to 2000  $\mu\text{m}$  and said second belt layer has a thickness ranging from 30 to 1,000  $\mu\text{m}$  and has a hardness greater than that of said first belt layer.

Claim 119 (New): The belt as claimed in claim 118, wherein a third belt layer different in material from said first belt layer and said second belt layer is formed on said second belt layer.

Claim 120 (New): The belt as claimed in claim 119, wherein the first raw liquid material provides said first belt layer with elasticity after curing while the second raw liquid material provides said second belt layer with hardness greater than hardness of said first belt layer after curing.

Claim 121 (New): The belt as claimed in claim 120, wherein said first belt layer and said second belt layer have a same major composition except for hardness.

Claim 122 (New): The belt as claimed in claim 118, wherein the first raw liquid material comprises thermosetting polyurethane rubber.

Claim 123 (New): The belt as claimed in claim 122, wherein said second belt layer has hardness of 75° or above, as measured by JIS A scale.

Claim 124 (New): The belt as claimed in claim 123, wherein said second belt layer has a Young's module ranging from 200 MPa to 3,000 MPa.

Claim 125 (New): The belt as claimed in claim 118, wherein the second raw liquid material comprises thermosetting polyurethane resin.

Claim 126 (New): The belt as claimed in claim 125, wherein the inside of the mold has smoothness of 1 micrometer or less in terms of a ten-point mean roughness (JIS).

Claim 127 (New): The belt as claimed in claim 126, wherein the inside of the mold has a gloss value of 80 or above.

Claim 128 (New): The belt as claimed in claim 118, wherein the first raw liquid material provides said first belt layer with elasticity after curing while the second raw liquid material provides said second belt layer with hardness greater than hardness of said first belt layer after curing.

Claim 129 (New): The belt as claimed in claim 118, wherein said first belt layer and said second belt layer have a same major composition except for hardness.

Claim 130 (New): The belt as claimed in claim 118, wherein the first raw liquid material comprises thermosetting polyurethane rubber.

Claim 131 (New): The belt as claimed in claim 118, wherein said second belt layer has hardness of 75° or above, as measured by JIS A scale.

Claim 132 (New): The belt as claimed in claim 118, wherein said second belt layer has a Young's module ranging from 200 MPa to 3,000 MPa.

Claim 133. The belt as claimed in claim 118, wherein the second raw liquid material comprises thermosetting polyurethane resin.

Claim 134 (New): The belt as claimed in claim 118, wherein the inside of the mold has smoothness of 1 micrometer or less in terms of a ten-point mean roughness (JIS).

Claim 135 (New): The belt as claimed in claim 118, wherein the inside of the mold has a gloss value of 80 or above.